

Date: Thursday, 17/08/2006 3:19:30 PM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	ARM
Job Number	: 28218A03		
Estimate Number	: 10145		
P.O. Number	: N/A	Part Number	: D2037101
This Issue	: 17/08/2006 S.O. No. : N/A	Drawing Number	: D2037 REV C3
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C3
Previous Run	: 26345	Material	: N/A
Written By		Due Date	: 14/09/2006
Checked & Approved By		Qty:	4
Comment	: Est Rev:A New Issue 05-11-01 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 4.1118 f(s)/Unit Total : 16.4472 f(s) Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049) Batch: M 101593	FF 06.08.30
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	
		1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1	FF 06.08.30
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037	FF 06.08.30
		2-Flatten ends of D2037-101 tube as required using DT8545	FF 06.08.31
		3-Deburr as required	FF 06.08.30
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	8B 06/08/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/09/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

PD 0608-1 (4)

6.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

1305/09/06 (4)

Job Completion



U 06-09-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

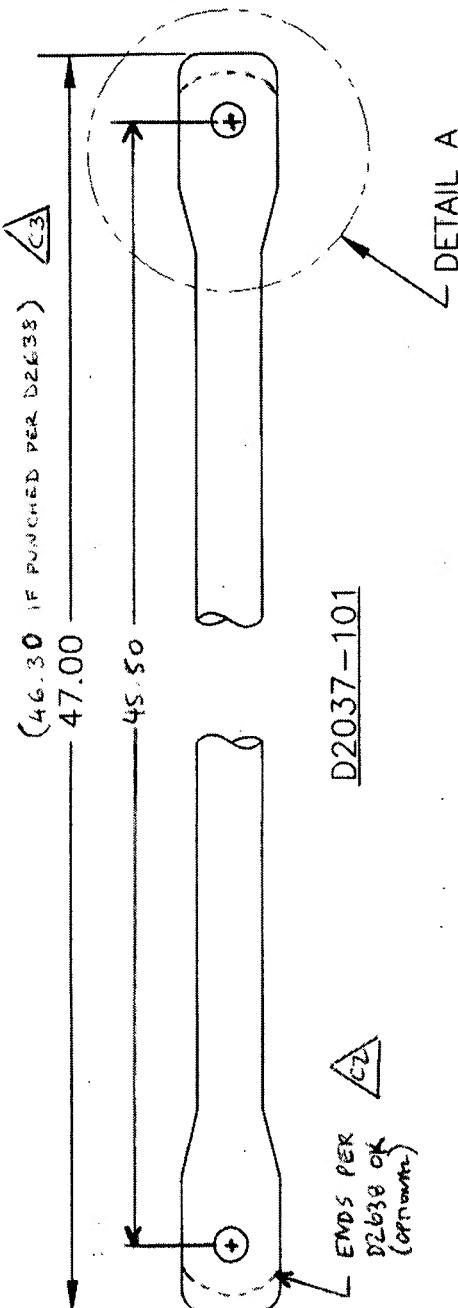
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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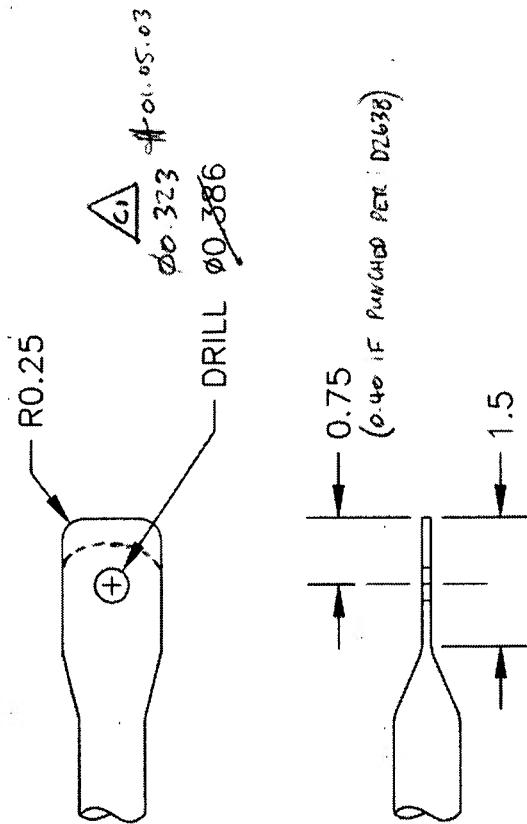
NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED J	DRAWING NO. D2037	REV. C SHEET 1 OF 1
DATE 99.06.07		TITLE ARM	SCALE NTS



A 91.10.22 NEW ISSUE
 B 93.04.20 -103 DELETED
 C 99.06.07 REDRAWN, 0.386 WAS 0.375
 C1 ~~if ip~~ 01.05.03 CHANGE TO $\phi 0.323$
 C2 ~~if ip~~ 02.06.14 ADD PUNCH PER D2638 AS OPTION



RELEASED
KE 99.06.10

DETAIL A

REFERENCE ONLY

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WALL

C3 05.04.27 ADD 46.30 PUNCHED PER D2638